

**Work Order ID 70777**

Wednesday, June 15, 2011 9:10:22 AM



Page 1

Item ID: D3189-1

Accept



Setup Start



Revision ID:

Item Name: Chafing Shield

Stop



Start Date: 6/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 106-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3189	Rev B

100



SHEAR

Waterjet

FLOW CNC Waterjet

Memo

0.00

 1-Cut as per Dwg  
 Dwg Rev: B  
 Prog Rev: B

2-Deburr if necessary

103



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00



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Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

105



QC

Quality Control

QC8- Inspect parts - second check

0.00

8 wloc129

Locutor  
422

110



Small Fab

Small Fab

0.00

22

Small Fab

Memo

0.00

SB 1107106

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 wloc106

Locutor  
422

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Page 3

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Start Date: 6/15/2011 Start Qty: 20.00



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Required Date: 6/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Identify as per dwg &amp; Stock Location:

0.00

*11/16/2011*

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*11/16/2011**mc**11-07-06*

# Picklist Print

Wednesday, June 15, 2011 9:10:28 AM

Page 1

Work Order ID: 70777



Parent Item: D3189-1



Parent Item Name: Chafing Shield

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B 05.08.22 No longer made in-house KJ/JLM  
IPP Rev:C 06-03-24 Rolling Now made in House JLM  
IPP Rev:D 07-04-16 As per Rev B JLM  
11.05.11 now made on waterjet DD verf:JLM

IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA  304/316 .020" Sheet		Purchased	No			100	sf	22.0000	0.32	6.736842	7	 BL-6-29	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT20	22	
117285	22	

117285

(22)

DART AEROSPACE LTD	Work Order:	70777
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: 11-6-29	Date: 11/06/29	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

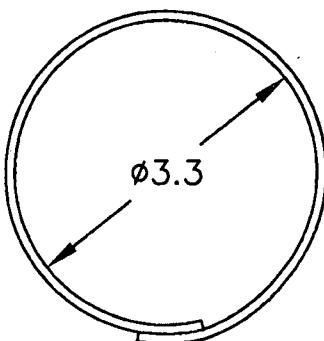
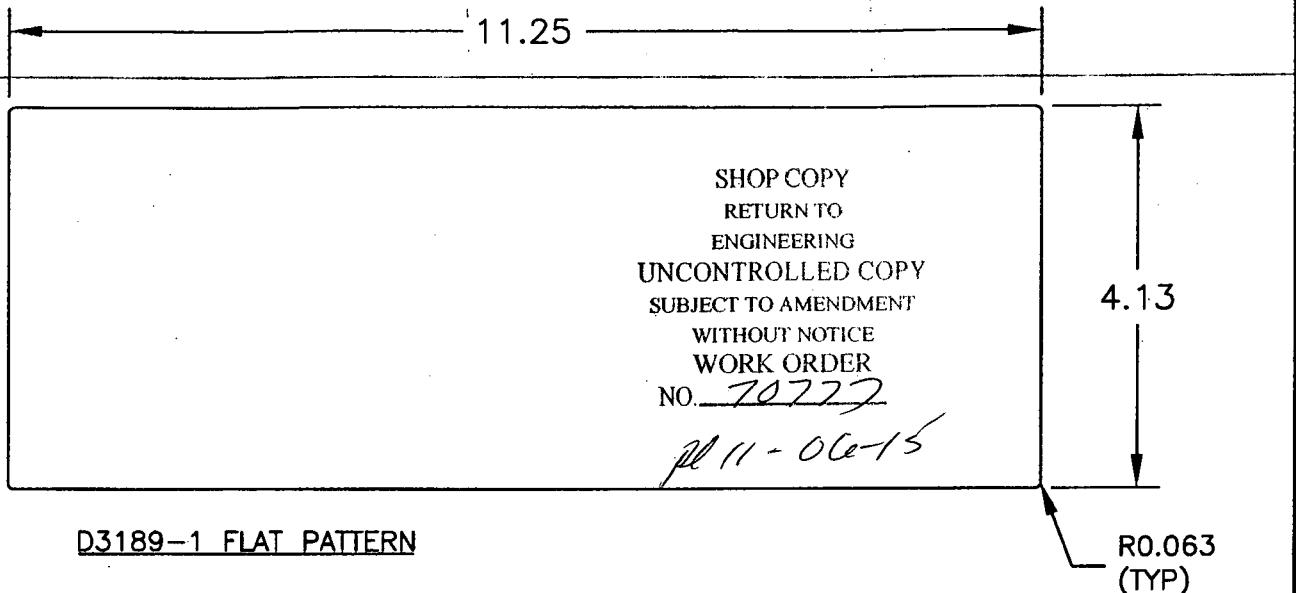
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	QP	DRAWN BY	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	APPROVED	<i>✓</i>	DRAWING NO. D3189 REV. B SHEET 1 OF 2
DATE	07.01.05			TITLE CHAFING SHIELD SCALE 1:2
A	03.05.08			NEW ISSUE
B	07.01.05			ADD -3

RELEASED

07.03.27 *✓*

D3189-1 ROLLING DETAIL  
NOT TO SCALE

#### D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

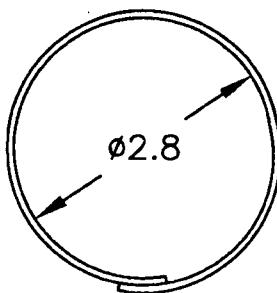
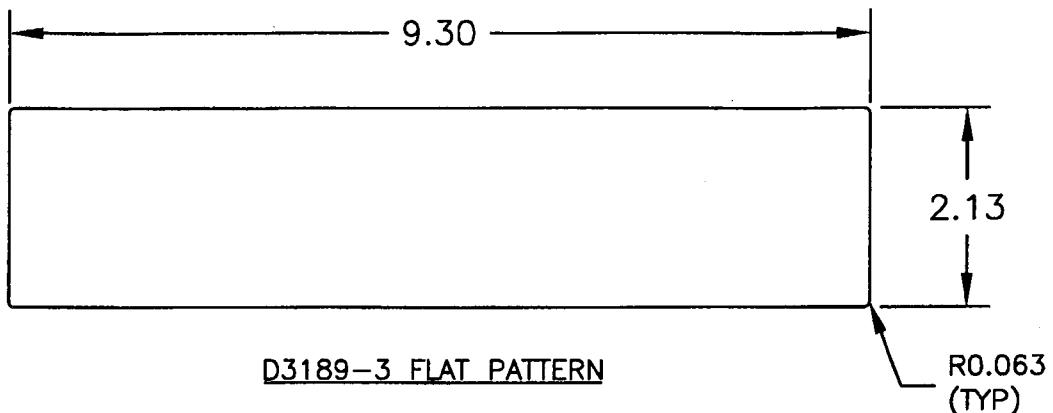
**DART**

DESIGN	9P	DRAWN BY	9P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<del>W</del>	APPROVED	<del>W</del>	DRAWING NO. D3189
DATE	07.01.05			REV. B SHEET 2 OF 2 SCALE 1:2

RELEASED

07.03.27 ~~W~~

W/0 76777



D3189-3 ROLLING DETAIL  
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries